

17-4 H900 Ø2.0

Work Order ID 123070

123070

Page 1

Tuesday, July 29, 2014 2:29:51 PM

Item ID: D4883-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: End Fitting

Start Date: 7/29/14 Start Qty: 10.00

10 11

Cust Item ID:

Required Date: 7/29/14 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: J.A Date: 14/07/30

Tooling: Date:

Run Start *NR1*

QC: Date:

SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4883	B

100 0.00

100

Doosan

DOOSAN LATHE

Memo

0.00

Doosan Lathe

1- Turn as per Dwg. D4883-1 Turning Detail & Folio FB252.

2- USE DT10003 For sizing blanks.

11 14-10-27

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

11 14-10-27

120

HAAS CNC VERTICAL MACHINING #1

0.00

120

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio Fb252 & Dwg D4883-1 END FITTING. deburr and Break all sharp edges.

14/12/12

11 14-10-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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123070

Page 2

Tuesday, July 29, 2014 2:29:51 PM

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NS1

Revision ID:

Stop

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Item Name: End Fitting

Start Date: 7/29/14

Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/29/14

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00

130

QC

Memo

0.00

Quality Control

see e-mail attached (last page)

J 14/12/12

140

QC8- Inspect parts - second check

0.00

140

QC

Memo

0.00

Quality Control

S. 14/12/14

DAS
08
9-89

150

Outsource process - NDT per QSI038 4.1

0.00

150

Outsource2

PURCHASING

Memo

0.00

Outsource process - NDT

Issue P/O: *\$27116*
LPI Per ASTM 1417 LEVEL 2
Certificate of conformaty is required.

CH 15/10/12 2 (11)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 123070

Tuesday, July 29, 2014 2:29:51 PM

123070

Item ID: D4883-1

Accept

N900040100

Setup Start *

Revision ID:

Stop *

Item Name: End Fitting

Start Date: 7/29/14

Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/29/14

Req'd Qty: 10.00

10

Customer:

Reference:

Run Start *

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
Numbr

155

Receive & Inspect for Damage & Mat'l Certs

0.00

155

Packaging

Memo

0.00

Packaging

Certificate of conformity is req'd.

11XSP1501-23

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

DAS
38
9-89

4

11

JAN 23 2015

210

~~QC21 Final Inspection - Work Order Release~~

0.00

210

QC

ID + STOCK
Memo

0.00

Quality Control

5/12/14

DAS
06
9-89

JAN 28 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Supplier									
Training									
Transport									
Unapproved									

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 123070

123070

Page 4

Tuesday, July 29, 2014 2:29:51 PM

Item ID: D4883-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: End Fitting

Start Date: 7/29/14

Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/29/14

Req'd Qty: 10.00

10

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

Identify as per dwg & Stock Location: _____

0.00

220

Packaging

QC 21

Memo

0.00

Packaging

15/1/28 28

15.1.28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, July 29, 2014 2:29:51 PM

Page 1

Work Order ID: 123070

123070

Parent Item: D4883-1

D4883-1

Parent Item Name: End Fitting

Start Date: 7/29/14

Required Date: 7/29/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV A RQ VERIFIED BY:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M174PH-H900R2.000

Purchased

No

f

45.6971

2.694737

M174PH-H900R2 000

SL 14-10-07

17-4SS H900 ROUND BAR 2.000

Location

Loc Qty

Loc Code

MAT031

45.6971

M128314

12.643

M128809

7.3458

M129892

25.7083

2.8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
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Process									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART AEROSPACE LTD		Work Order:	123070
Description:		Part Number:	
Inspection Dwg:		Rev:	Page 1 of 1

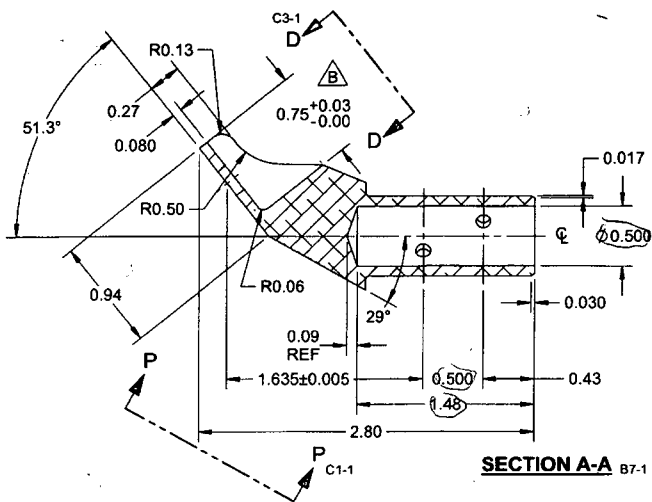
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
670	+0 -0.01	670	/		mic	SL-4
1.41	+0.030	1.410	/		vern	SL-10
500	+0.006 -0.001	504	/		-	
1.480	+0.030	1.468	/		-	
500	+0.010	500	/		H-G	
43	+0.030	430	/		vern	
125	+0.004 -0.001	126	/		-	
.27	±0.030	.260	✓			
.080	±0.010	.085	✓			
.94	±0.030	.957	✓			
2.80	±0.030	2.795	✓			
1.635	±0.005	1.631	✓			
.75	+0.03 -0.0	.755	✓			
.93	±0.030	.931	✓			
57.3°	±1/2°	51°	✓			
29°	±1/2°	28.9°	✓			
249	+0.001 -0.001	249	✓			
.38	±0.030	.372	✓			
.750	±0.03	.757	✓			

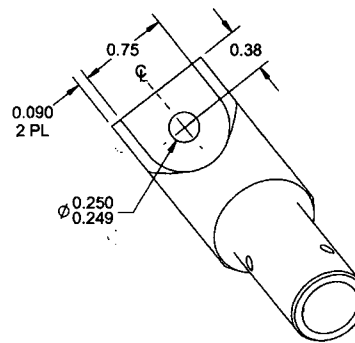
Measured by:	SL/JP	Audited by:	D.A.	DAS	Preliminary Approval:	
Date:	14-10-26	Date:	14/12/14	08 9-89	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

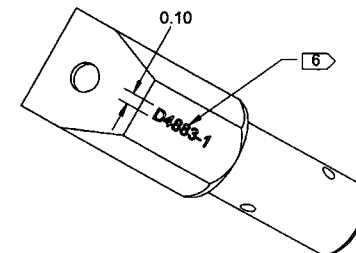
10.04.15



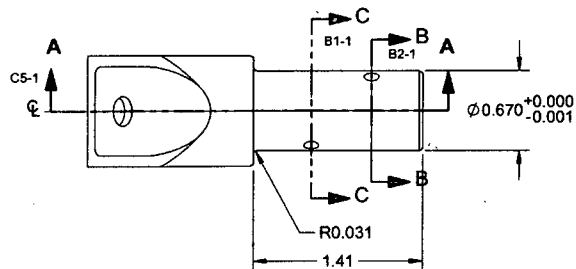
SECTION A-A B7-1



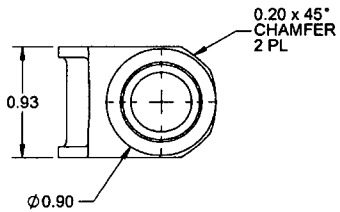
AUXILIARY VIEW D-D D7-1



AUXILIARY VIEW P-P C6-1



SECTION B-B B6-1



SECTION C-C B6-1

D4883-1 END FITTING

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3.
ENGRAVE P/N USING 0.10 HIGH LETTERS TO A MAX. DEPTH OF 0.010
- 7) WEIGHT: 0.22 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

RELEASED
2014-06-16

J.A 14107130 123070

B	REMOVED R1.0 & ADD 0.75 TOLERANCE (ZN D7-1, D7-2, D6-3, D7-4); 1.783 WAS 1.794 (ZN C7-2)	RF	14.04.08
A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	JFS		
APPROVED	HS		
DE APPR.	DS		
DATE	14.04.08		

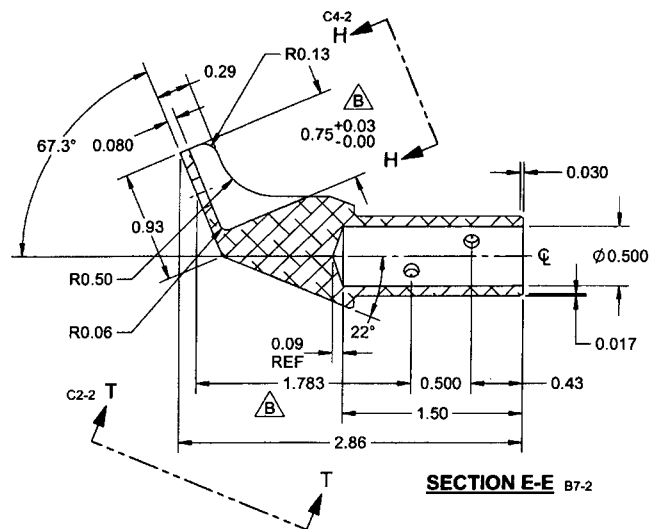
APPROVED

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

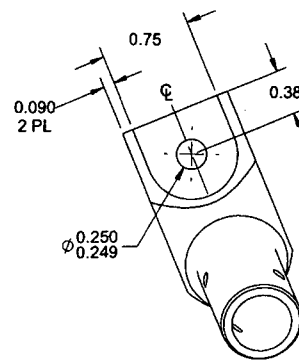
DRAWING NO. **D4883** REV. B
SHEET 1 OF 4

TITLE **END FITTING** SCALE NTS

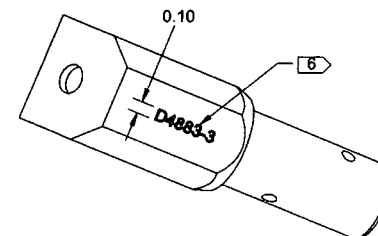
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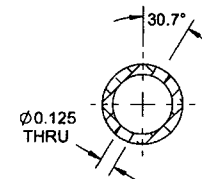
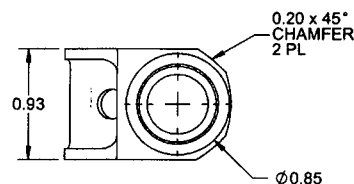
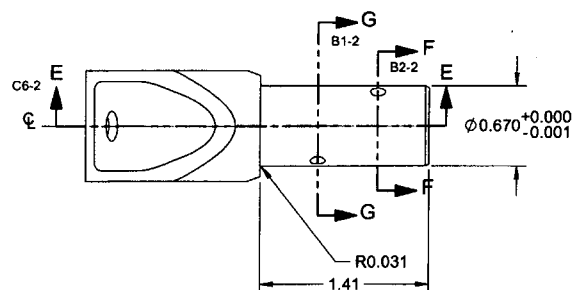
SECTION E-E B7-2



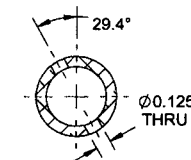
AUXILIARY VIEW H-H D7-2



AUXILIARY VIEW T-T C7-2



SECTION F-F B6-2



SECTION G-G B6-2

D4883-3 END FITTING

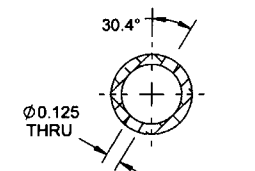
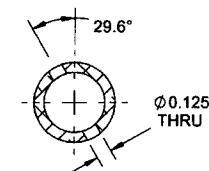
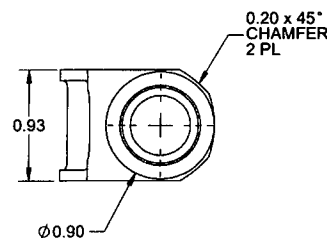
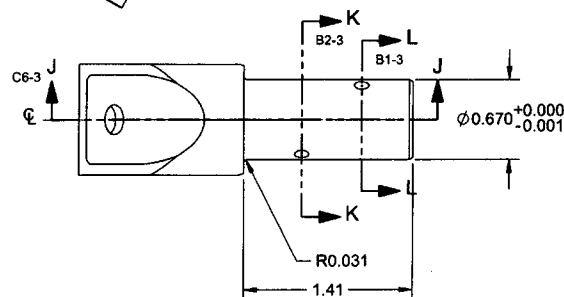
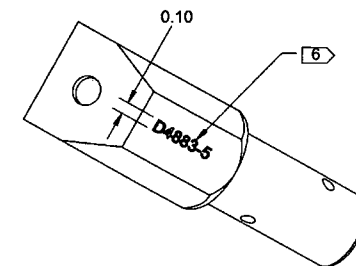
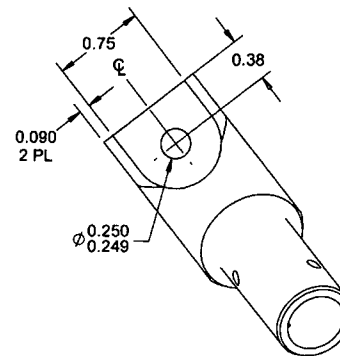
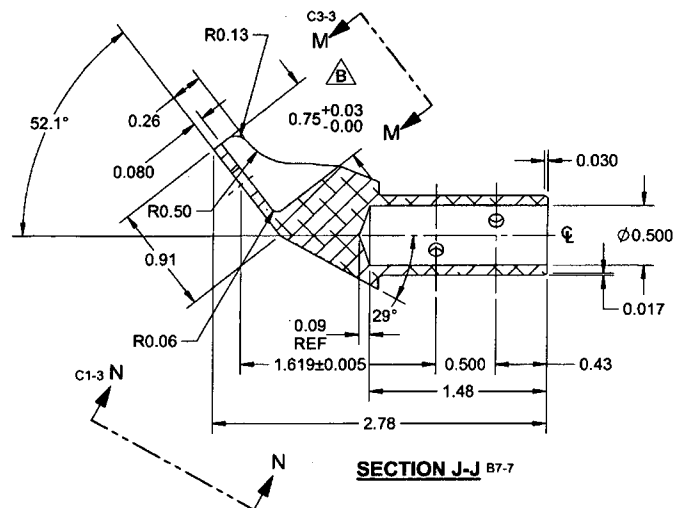
RELEASED
2014-06-18

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3.
ENGRAVE P/N USING 0.10 HIGH LETTERS TO A MAX. DEPTH OF 0.010
- 7) WEIGHT: 0.25 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D4883	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	END FITTING	NTS
DATE	14.04.08	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT SYSTEM PERMISSION FROM DART AEROSPACE LTD.	



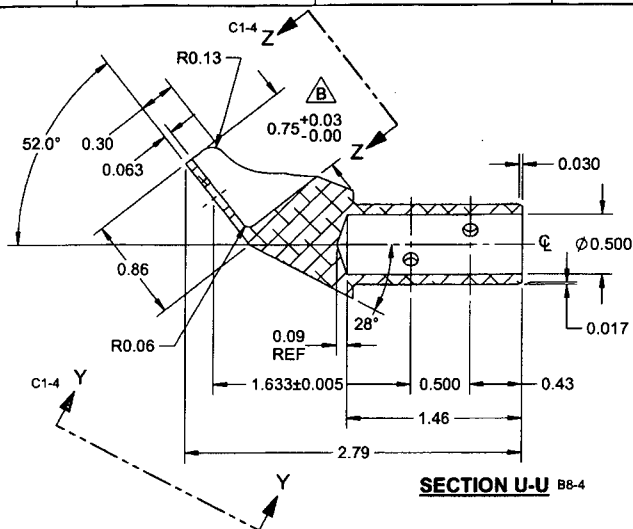
D4883-5 END FITTING

NOTES:

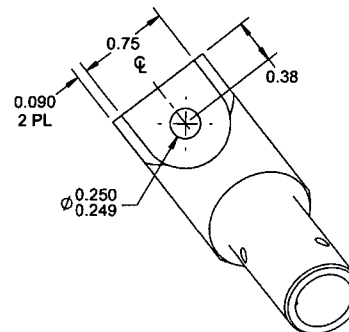
- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3.
ENGRAVE P/N USING 0.10 HIGH LETTERS TO A MAX. DEPTH OF 0.010
- 7) WEIGHT: 0.22 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

RELEASED
2014-06-16

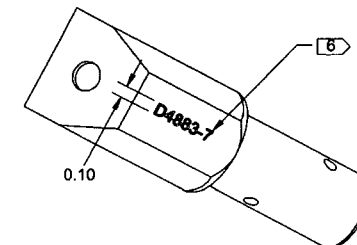
APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO.	REV. B
	MFG. APPR.	JFS	D4883	SHEET 3 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	END FITTING	NTS
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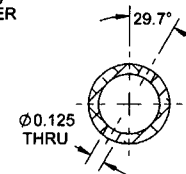
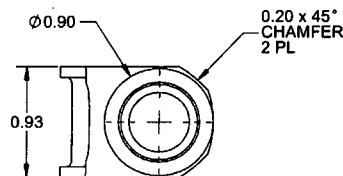
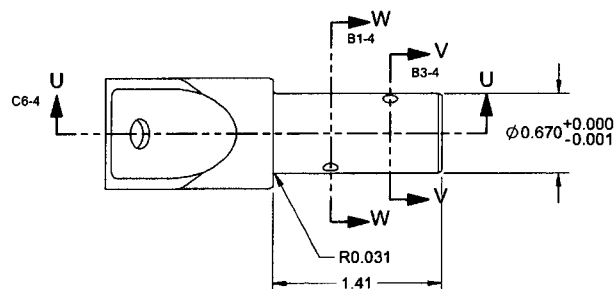
SECTION U-U B6-4



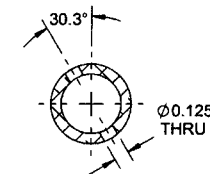
AUXILIARY VIEW Z-Z B6-4



AUXILIARY VIEW Y-Y D7-4



SECTION V-V B6-4



SECTION W-W B6-4

D4883-7 END FITTING

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3.
ENGRAVE P/N USING 0.10 HIGH LETTERS TO A MAX. DEPTH OF 0.010
- 7) WEIGHT: 0.22 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

RELEASED
2014-06-16

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO. D4883	REV. B
	MFG. APPR.	JFS	SHEET 4 OF 4	
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	END FITTING	NTS
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Regis Quenneville

From: Roberto Fuentes
Sent: July-15-14 11:00 AM
To: Regis Quenneville; Jean-Luc Menard; Harvey Siemens
Subject: RE: 4883-5 EXAMPLE

Hi JL,

Regarding to sketch below of D4883-1/-3/-5/-7 and similar end fitting profile is acceptable angle be greater than 90 degree produce of cut profile 0.75" in Sections A-A, E-E, J-J, U-U, but bottom part of this section need to be parallel with base.

Roberto

From: Regis Quenneville
Sent: July-15-14 8:14 AM
To: Jean-Luc Menard; Roberto Fuentes
Subject: 4883-5 EXAMPLE



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27116**

Purchase Order Date 1/19/2015

PO Print Date 1/22/2015

Page Number 4 of 4

Order From :
SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

VC-SKY001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 905-678-5636

Ship To Contact
Ship To Phone
Ship Via: Delivered
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

123070	D4883-1 END FITTING	1/19/2015	11.00	✓	\$0.00	\$0.00
		Yes				
		1/19/2015				

LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

SP 15-01-23

Line Total: \$0.00

9 121511	D4837-1 STRUT	1/19/2015	8.00		\$0.00	\$0.00
		Yes				
		1/19/2015				

LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

Line Total: \$0.00

PO Total: \$775.00

CL

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 3

Change Date: 1/22/2015



skyservice Work Order Traveler

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO23362	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: 27116
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 2

Work Required:

CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 24 MISC PART:

ID#: D4883-1 END FITING (QTY 11)

1 - WORK ORDER ID#: 123070

ID#: D4802-1 STRUT (QTY 5)

2 - WORK ORDER ID#: 127715

ID#: D4837-1 STRUT (QTY 8)

3 - WORK ORDER ID#: 121511

SP 15-01-21

Action Taken:						Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-3) AS PER ASTM1417M-13						JAN 20 2015	177 AM f
NO CRACK FOUND							
Pen: ZL-56 BATCH# 09H094 EXP. DATE: AUG 2014, DEV: SKD-S2 EXP. DATE: OCT2017 CLEANER: SKC-S EXP. DATE: APR 2018							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	
		DA6 38 9-89					
		JAN 23 2015					

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:		ACA/SCA Stamp	Date:
Name:		177 AM f	JAN 20 2015